

Ship June 11

Work Order ID 133360

133360

Page 1

Monday, June 08, 2015 8:54:13 AM

Item ID: D4049-141

Accept

N900040100

Setup Start

PRELIMINARY ISSUE

Revision ID: PRELIM

Item Name: Mounting Lug Assembly, LH

Stop

NS2

Start Date: 6/08/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/10/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date: 5-6-8

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4049

C1

100

Weld per dwg A/R S.S. rod Batch: M123823 0.00

100

Large Fab

Memo

0.00

Large Fab

1- Weld lug on bracket as per dwg D4049 using DT jig
 2- Tack weld a piece of s.s. rod on back of D4049-13 where lug is located, to hang the part when powdercoating.

2 2 15-6-10

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

2 JUN 10 2015

DAS
24
9-89

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

2 JUN 10 2015

DAS
24
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause <div style="display: flex;"> <div style="width: 50%;"> Envirohment <input type="checkbox"/> Design <input type="checkbox"/> Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Pre <input type="checkbox"/> Material <input type="checkbox"/> Internal Transport <input type="checkbox"/> Tribal Knowledge <input type="checkbox"/> LOA <input type="checkbox"/> Substation <input type="checkbox"/> Past Expiry Date <input type="checkbox"/> Misidentified <input type="checkbox"/> </div> <div style="width: 50%;"> No Re-verification <input type="checkbox"/> Operator <input type="checkbox"/> Offset/Setup <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Use for Testing <input type="checkbox"/> Poor Information <input type="checkbox"/> Rushing <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Past Due <input type="checkbox"/> </div> </div>		FAULT CATEGORY <div style="display: flex;"> <div style="width: 33%;"> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> </div> <div style="width: 33%;"> Temperature/Cure <input type="checkbox"/> Set-up <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Drill Holes <input type="checkbox"/> </div> <div style="width: 33%;"> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set <input type="checkbox"/> Misabeled <input type="checkbox"/> Fit/Function <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> </div> <div style="width: 33%;"> Positioned Wrong <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Misread <input type="checkbox"/> Turning Sequence <input type="checkbox"/> </div> </div>			
		OTHER : _____			

Work Order ID 133360

Monday, June 08, 2015 8:54:13 AM

133360

Page 2

Item ID: D4049-141 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Mounting Lug Assembly, LH
Start Date: 6/08/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/10/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130	<i>M 131 545</i>					<i>2</i>	<i>0</i>	<i>15-6-10</i>	
Powdercoat	Memo	0.00							
Powder Coating	1- POWDER COAT: Start Time: <i>11:20:4000</i> Oven Temperature: Finish Time: <i>12:20</i>								
	2- When powdercoated, ONLY grind off welding rod flush								
	3- touch up with paint								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS 34 9-89

DAS 38 9-89

JUN 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment <input type="checkbox"/>	No Re-verification <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
Design <input type="checkbox"/>	Operator <input type="checkbox"/>	Bending <input type="checkbox"/>	Set-up <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>				
Doc/Data <input type="checkbox"/>	Offset/Setup <input type="checkbox"/>	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>				
Equip/Tooling <input type="checkbox"/>	Supplier <input type="checkbox"/>	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Weld <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>				
Handling/Pre <input type="checkbox"/>	Training <input type="checkbox"/>	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>				
Material <input type="checkbox"/>	Use for Testing <input type="checkbox"/>	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	Part Moved <input type="checkbox"/>				
Internal Transport <input type="checkbox"/>	Poor Information <input type="checkbox"/>	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Off-set <input type="checkbox"/>	Drawing <input type="checkbox"/>				
Tribal Knowledge <input type="checkbox"/>	Rushing <input type="checkbox"/>	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Finish <input type="checkbox"/>				
LOA <input type="checkbox"/>	Product Improvement <input type="checkbox"/>	Wave/Twist in Tube <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Misread <input type="checkbox"/>				
Substation <input type="checkbox"/>	Process Improvement <input type="checkbox"/>	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Turning Sequence <input type="checkbox"/>				
Past Expiry Date <input type="checkbox"/>	Manufacturing Process <input type="checkbox"/>	OTHER : _____							
Misidentified <input type="checkbox"/>	Past Due <input type="checkbox"/>								

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Page 3

Item ID: D4049-141 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Mounting Lug Assembly, LH
Start Date: 6/08/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/10/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
145						(2)			

QC Memo 0.00
Quality Control

JUN 11 2015

150 Identify as per dwg & Stock Location: **PRELIM** 0.00
150
Packaging Memo 0.00
Packaging

2 **HS 6-15**

160 QC21- Final Inspection - Work Order Release 0.00
160
QC Memo 0.00
Quality Control

POSITIVE RECALL
EFFECTIVE **HS** AUTH **HS 6-8**
RELEASED _____ DATE _____

HS 6-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment <input type="checkbox"/>	No Re-verification <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>
Design <input type="checkbox"/>	Operator <input type="checkbox"/>	Bending <input type="checkbox"/>	Set-up <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>
Doc/Data <input type="checkbox"/>	Offset/Setup <input type="checkbox"/>	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>
Equip/Tooling <input type="checkbox"/>	Supplier <input type="checkbox"/>	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Weld <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>
Handling/Pre <input type="checkbox"/>	Training <input type="checkbox"/>	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>
Material <input type="checkbox"/>	Use for Testing <input type="checkbox"/>	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	Part Moved <input type="checkbox"/>
Internal Transport <input type="checkbox"/>	Poor Information <input type="checkbox"/>	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Off-set <input type="checkbox"/>	Drawing <input type="checkbox"/>
Tribal Knowledge <input type="checkbox"/>	Rushing <input type="checkbox"/>	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Finish <input type="checkbox"/>
LOA <input type="checkbox"/>	Product Improvement <input type="checkbox"/>	Wave/Twist in Tube <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Misread <input type="checkbox"/>
Substation <input type="checkbox"/>	Process Improvement <input type="checkbox"/>	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Turning Sequence <input type="checkbox"/>
Past Expiry Date <input type="checkbox"/>	Manufacturing Process <input type="checkbox"/>	OTHER : _____			
Misidentified <input type="checkbox"/>	Past Due <input type="checkbox"/>				

Monday, June 08, 2015 8:54:19 AM

Page 1

133360

D4049-141

Required Date: 6/10/15

Required Qty: 2.00

Comments: IPP REV:A 15.06.08 NEW ISSUE DD VERF:JLM

[illegible]

DQA: _____ Date: _____



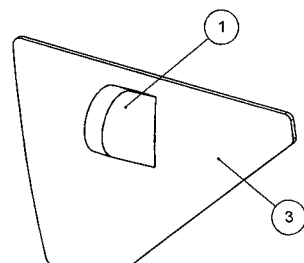
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

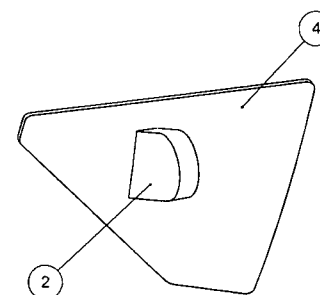
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause <div style="display: flex;"> <div style="flex: 1;"> Environment <input type="checkbox"/> Design <input type="checkbox"/> Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Pre <input type="checkbox"/> Material <input type="checkbox"/> Internal Transport <input type="checkbox"/> Tribal Knowledge <input type="checkbox"/> LOA <input type="checkbox"/> Substation <input type="checkbox"/> Past Expiry Date <input type="checkbox"/> Misidentified <input type="checkbox"/> </div> <div style="flex: 1;"> No Re-verification <input type="checkbox"/> Operator <input type="checkbox"/> Offset/Setup <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Use for Testing <input type="checkbox"/> Poor Information <input type="checkbox"/> Rushing <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Past Due <input type="checkbox"/> </div> </div>		FAULT CATEGORY <div style="display: flex;"> <div style="flex: 1;"> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> </div> <div style="flex: 1;"> Temperature/Cure <input type="checkbox"/> Set-up <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Drill Holes <input type="checkbox"/> </div> <div style="flex: 1;"> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set <input type="checkbox"/> Mislabelled <input type="checkbox"/> Fit/Function <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> </div> <div style="flex: 1;"> Positioned Wrong <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Misread <input type="checkbox"/> Turning Sequence <input type="checkbox"/> </div> </div>			
		OTHER : _____			

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D4049-041	MOUNTING LUG ASSY, LH
		X	D4049-042	MOUNTING LUG ASSY, RH
1	1		D4049-1	LUG
2		1	D4049-2	LUG
3	1		D4049-3	MOUNTING PLATE, LH
4		1	D4049-4	MOUNTING PLATE, RH



D4049-041 MOUNTING LUG ASSY, LH



D4049-042 MOUNTING LUG ASSY, RH

Handwritten signature and date:
 15.6.8
 133360

PRELIMINARY ISSUE

C	ADD -141/-142; ZN B4-3, B8-3, B4-6, B3-5, ADD -11/-12; ZN A4-10, B2-11, ADD -13/-14; ZN C1-12, A1-12, REVISE DIM; ZN B5-3, B4-4, ADD -2 VIEW; ZN B2-7	VS	15.05.26
B	80° WAS 83°, 0.33 WAS 0.55 & 2.10 WAS 2.50 (ZN C6-2)	RF	10.03.19
A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 1 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

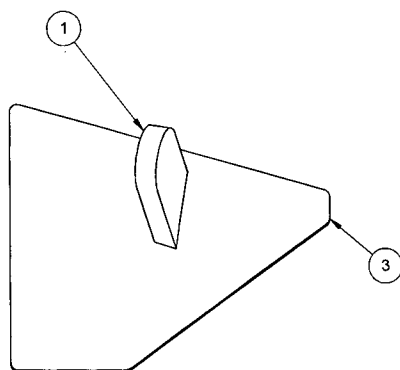
8 7 6 5 4 3 2 1

D

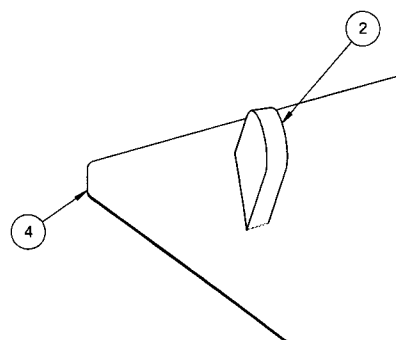
C

B

A



 **D4049-141 MOUNTING LUG ASSY, LH**



 **D4049-142 MOUNTING LUG ASSY, RH**

ITEM	QTY -141	QTY -142	P/N	DESCRIPTION
	X		D4049-141	MOUNTING LUG ASSY, LH
		X	D4049-142	MOUNTING LUG ASSY, RH
1	1		D4049-11	LUG
2		1	D4049-12	LUG
3	1		D4049-13	MOUNTING PLATE, LH
4		1	D4049-14	MOUNTING PLATE, RH

D

C

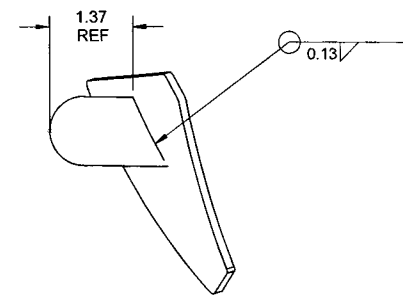
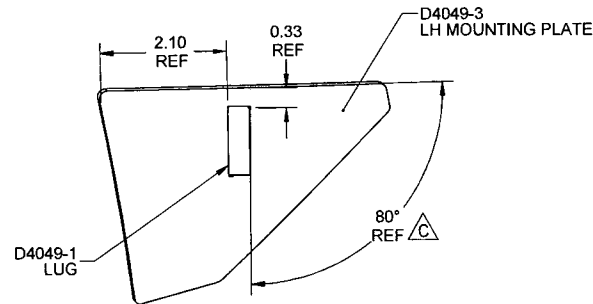
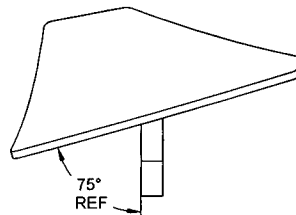
B

A

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. D4049	REV. C1
MFG. APPR.	DD		SHEET 2 OF 12
APPROVED		TITLE MOUNTING LUG ASSY	SCALE NTS
DE APPR.			
DATE	15.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



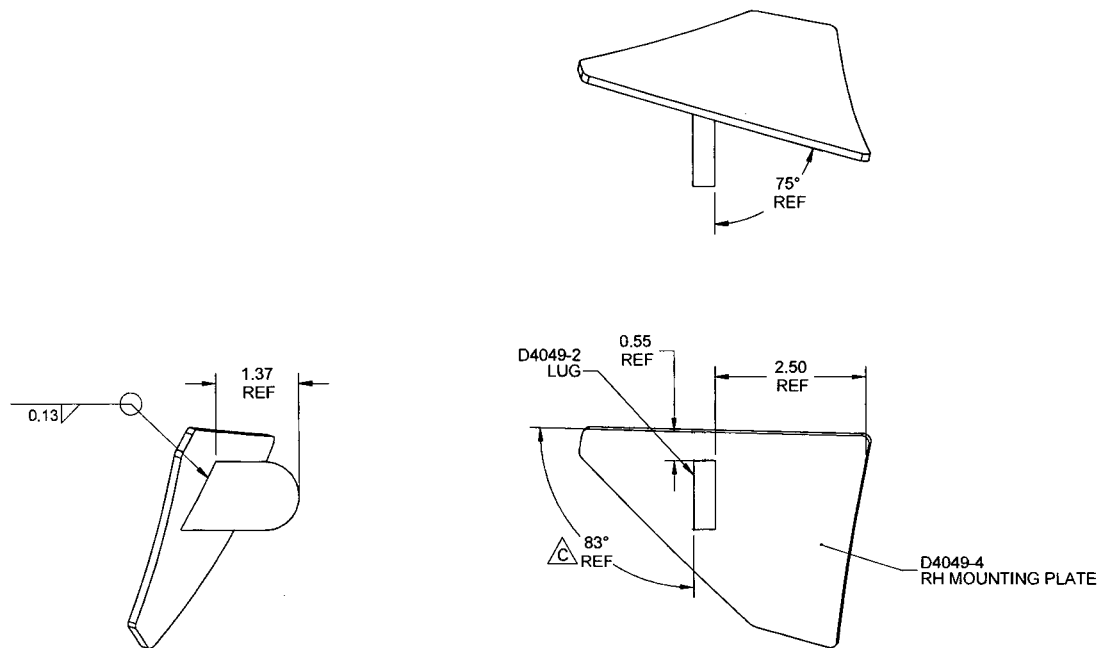
8 D4049-041 MOUNTING LUG ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9584

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 3 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4049-042 MOUNTING LUG ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9583

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. D4049	REV. C1
MFG. APPR.	DD		SHEET 4 OF 12
APPROVED		TITLE MOUNTING LUG ASSY	SCALE NTS
DE APPR.		<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	15.05.26		

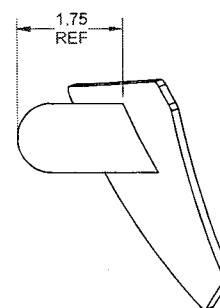
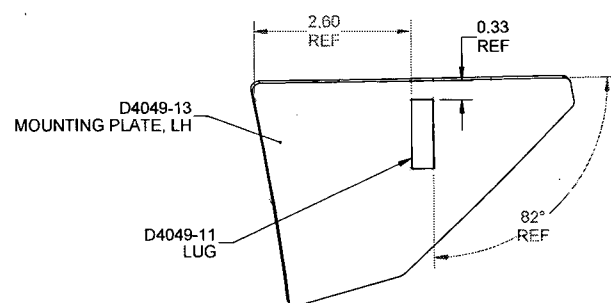
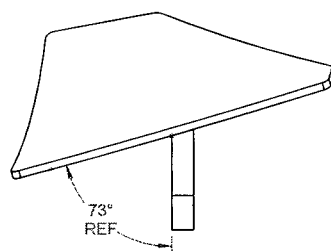
8 7 6 5 4 3 2 1

D

C

B

A



8 D4049-141 MOUNTING LUG ASSY, LH C

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-141" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.77 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DTXXXX

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 5 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
DATE	15.05.26	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

C

B

A

8 7 6 5 4 3 2 1

D

D

C

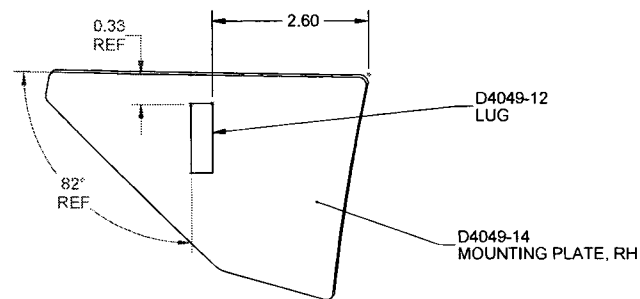
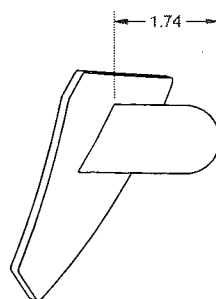
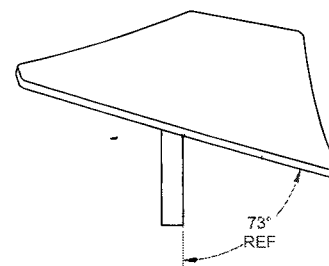
C

B

B

A

A



8 D4049-142 MOUNTING LUG ASSY, RH C

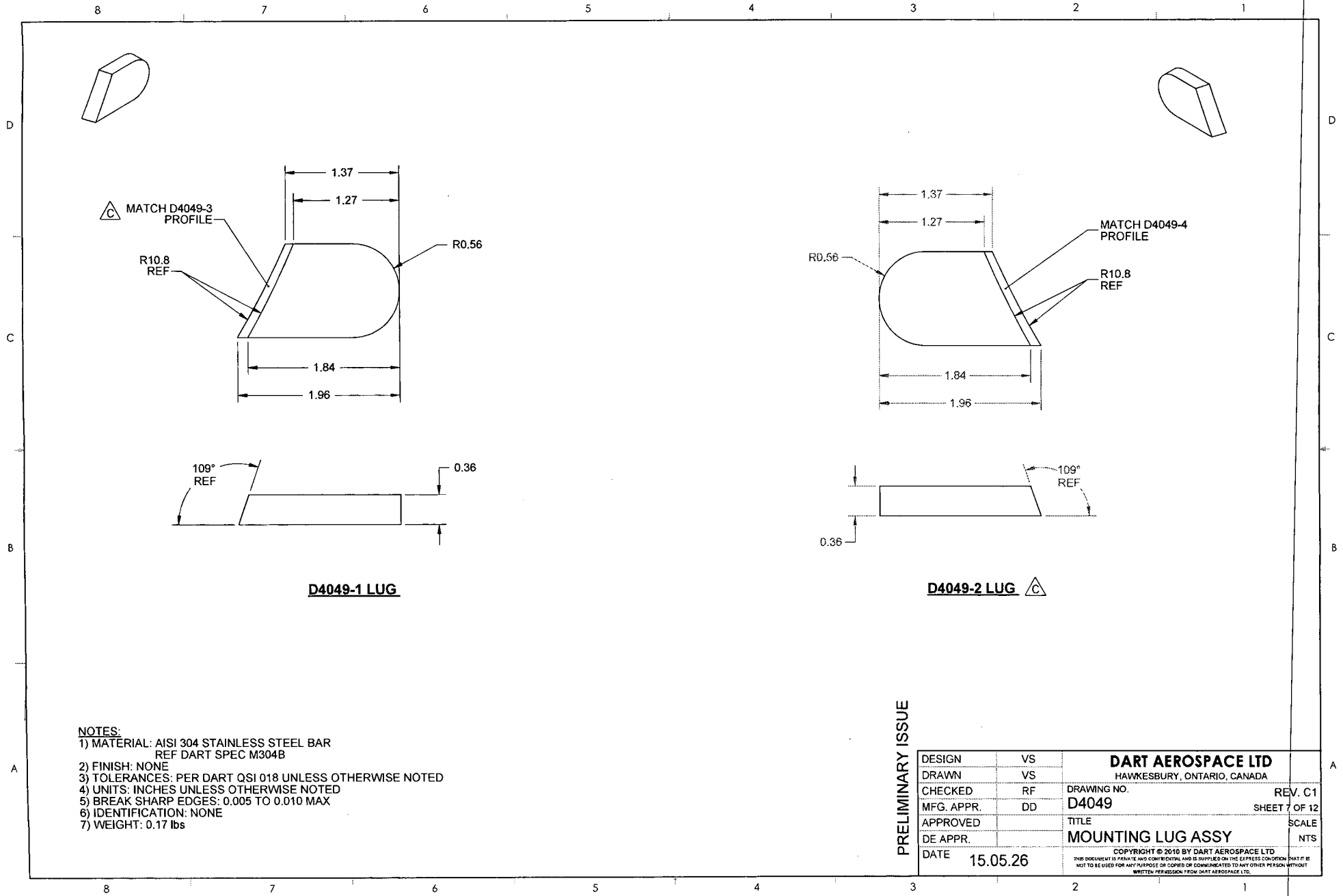
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-142" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.77 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DTXXXX

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 8 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
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8 7 6 5 4 3 2 1



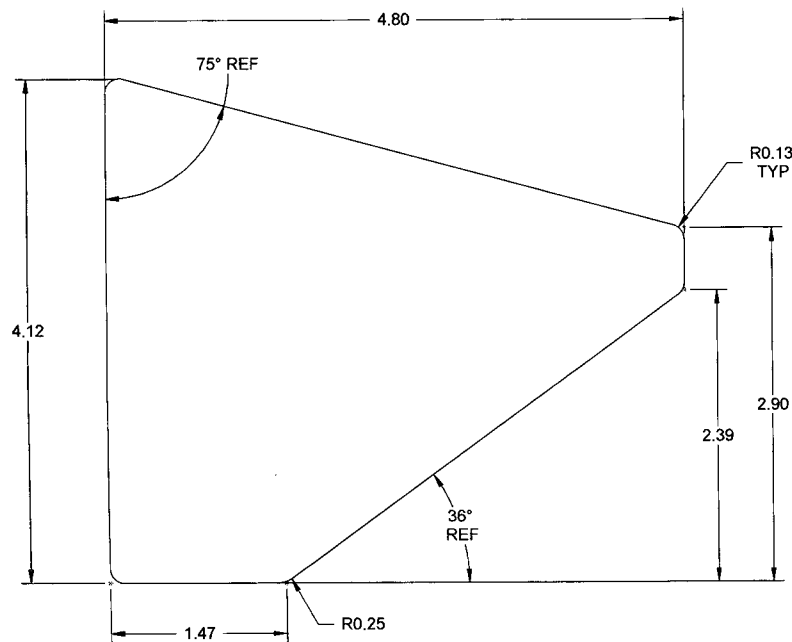
D4049-1 LUG

D4049-2 LUG

- NOTES:**
 1) MATERIAL: AISI 304 STAINLESS STEEL BAR
 REF DART SPEC M304B
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.17 lbs

PRELIMINARY ISSUE

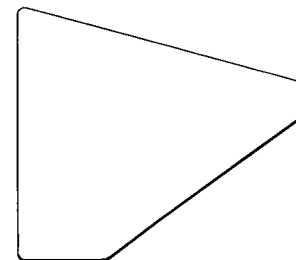
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 7 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
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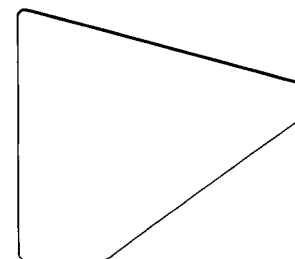
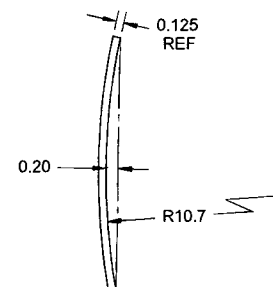
D4049-3F FLAT PATTERN

NOTES:

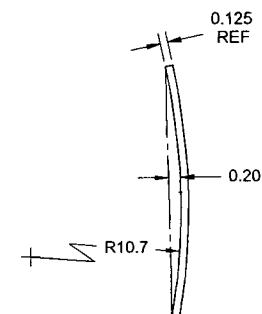
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs



D4049-3 MOUNTING PLATE, LH
(MAKE FROM D4049-3F FLAT PATTERN)

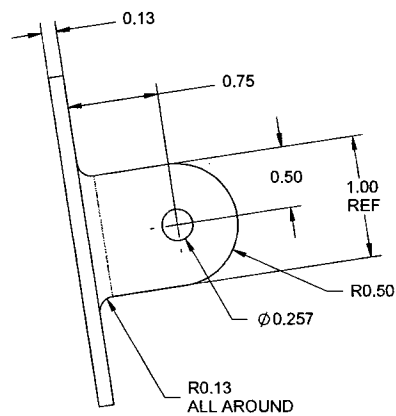


D4049-4 MOUNTING PLATE, RH
(MAKE FROM D4049-3F FLAT PATTERN)

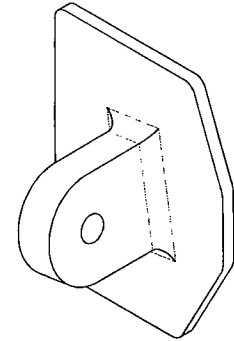
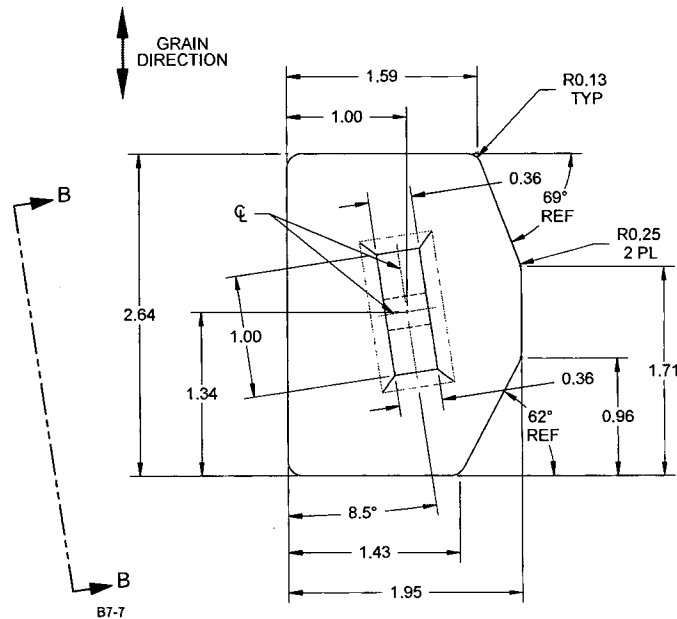


PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 8 OF 12
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG ASSY	NTS
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VIEW B-B 85-7



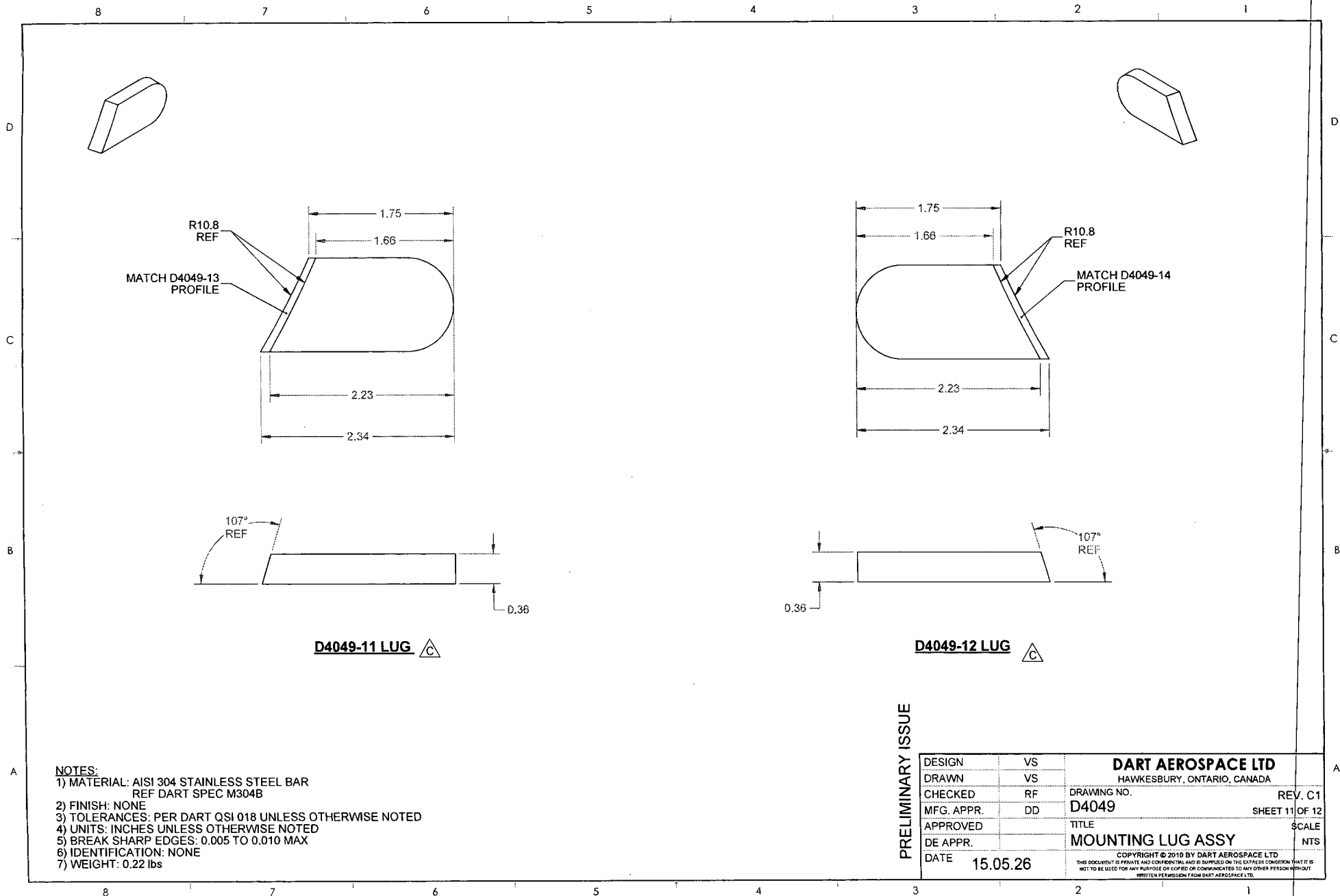
D4049-8 MOUNTING LUG, RH

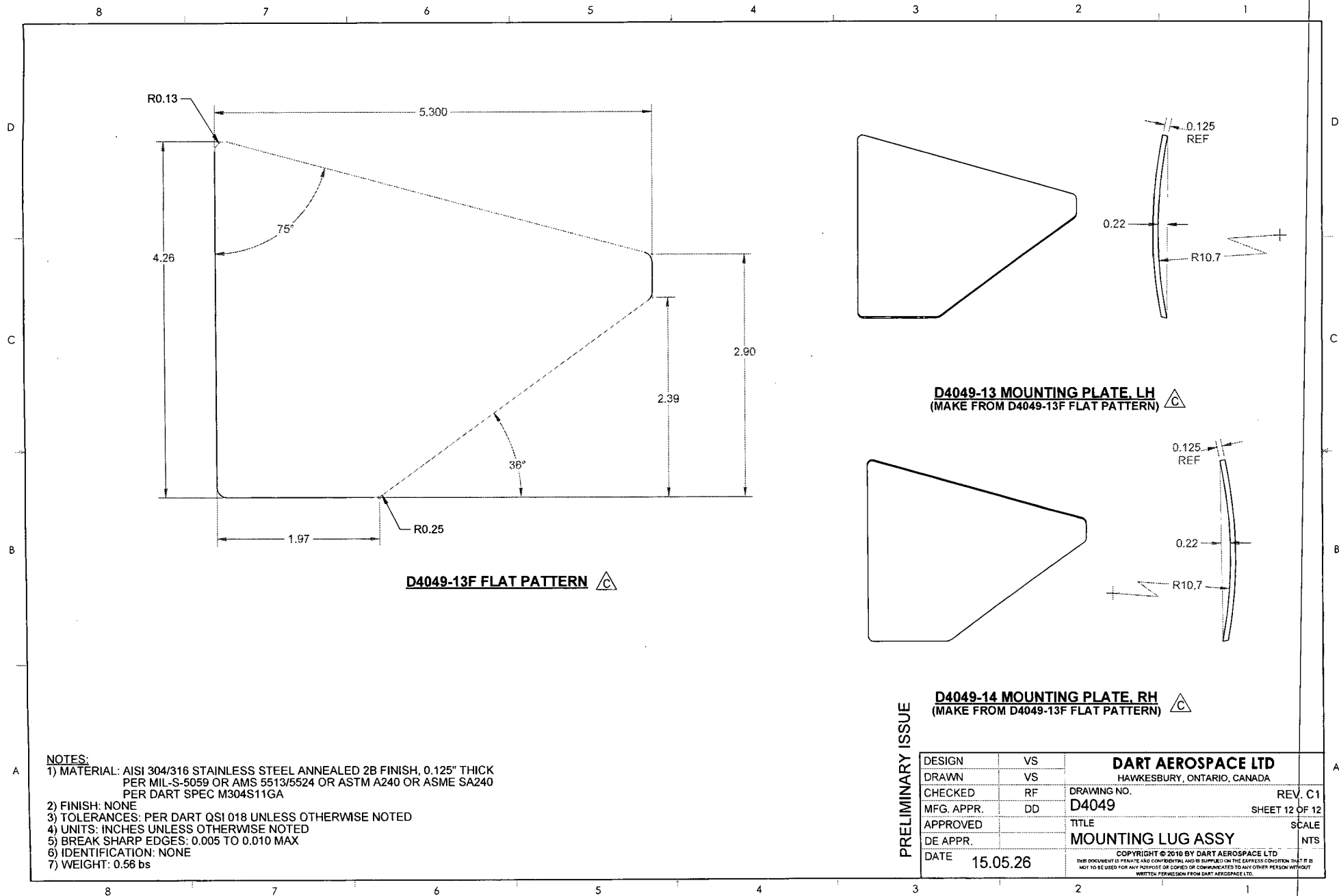
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-8" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 10 OF 12
APPROVED		TITLE	SCALE
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.56 bs

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C1
MFG. APPR.	DD	D4049	SHEET 12 OF 12
APPROVED		TITLE	SCALE
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JTG DT 9584 INSPECTION SHEET

Measured by:	<i>Q</i>	Checked by:		QC Inspector:	
Date:	<i>15-6-10</i>	Date:		Date:	

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	